

Date: Thursday, 24/07/2008 3:13:55 PM
 Use: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D206-558-041
 Job Number : 40748 Part Number : D206558041
 Estimate Number : 10804 Drawing Number : ECN08-504
 P.O. Number : Project Number :
 This Issue : 24/07/2008 S.O. No. : Drawing Revision :
 Prsht Rev. : NC Material :
 First Issue : 1 / 1 Type : SMALL / MED FAB Due Date : 05/08/2008
 Previous Run : 00015 Qty: 18 Um: Each
 Written By :
 Checked & Approved By :
 Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3X D206-558-041 B 38580 ✓ FFx3 08-07-30

PULL FROM STOCK:

3 X D206-558-041 B39281

10 X D206-558-041 B39398 ✓

5 X D206-558-041 B39399 ✓

FFx10 } 08-07-30
 FFx5 }

2.0 D206558041 Single Cargo Mirror Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)

Single Cargo Mirror Assembly

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

CUT ARMS TO REMOVE ALL COMPONENTS

D2011-101 MIRROR

D2052 MTG BRKT

D2054 BUSHING

D2055 CLAMP

D2056 BELL CRANK

D2057 PLUG

PUT COMPONENTS ASIDE TO RE-USE WITH NEW ARM

DISCARD HARDWARE

MANUFACTURE NEW ARMS WITH .049 WALL MAT'L

FF 08-07-30

— FF 08-07-30

DARTDart Aerospace Ltd.
1270 ABERDEEN ST.
HAWKESBURY, ON, CANADA K6A 1K7

TC APPROVAL # 09-89

TEL: 1-613-632-5200

P/N	D206-558-041	CHG	CHG006
DESC.	Single Cargo Mirror Assy	STC	SH92-17
LOT	B39398	STC	SH1031NE
MODEL	206A/B/L/L1/L3/L4/407	STC	

MADE IN CANADA

D2729-1

DARTDart Aerospace Ltd.
1270 ABERDEEN ST.
HAWKESBURY, ON, CANADA K6A 1K7

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MADE IN CANADA

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Drawing Name: D206-558-041

Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 1.7500 f(s)/Unit Total: 31.5006 f(s)

304 RD Tube .500 x .049W

304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012

(M04TR0.500W049)

Identify as D2065.

Note: 1 end only

Batch

108324

M 108324
M 108823
FF 08-07-31

(5)
(3)
(10)

take 10x D2065 from B 40580

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch 1/2" OD x .035" Wall AISI

Signed For SR.
FF 08-07-31 - (10)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Cut to length as per Dwg D2065

Bend as per Dwg D2065 and template D2065T1

Flatten the end on Hydraulic press using Dt 8545

Drill .00188" holes as per Dwg D2065 and template D2065 T1 and using Dt 8768 Drill Jig.

Deburr.

FF 08-07-31
FF 08/09/15
(10)
10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soboleski
Soboleski
(10)
(10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320
11:30

M-H 08/07/31

M 102316 START Time: 9:25 AM
Temp: 320°F
FINISH 9:55 AM
08-09-15

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-041

J6b Number: 40748

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M-P 08/04/05



10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/07/31

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



P40

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-558

USING ORIGINAL COMPONENTS
AND NEW HARDWARE:

FF 08/10/09

FF 08-08-01

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~72~~ 36.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

M109059

4 AN960JD10

Washer

M100550

FF 08/10/09

FF 08-08-01

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~36~~ 18.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

M1008701

2 MS21042L3

Nut

M107665

or MS21042-3

FF 08/10/09

FF 08-08-01

13.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~36~~ 18.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

M1008161

2 MS27039-1-18

Screw

M1008161

FF 08/10/09

FF 08-08-01

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/09

(X5)

Date: Thursday, 24/07/2008 3:13:55 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-041

Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR
ORIGINAL KITS TO BE INCLUDED.

S 08/10/14 (FE)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



S 08/10/14
Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP
USING NEW B/N @ CHG 007
NEW LABELS REQUIRED
ADD PAPERWORK DSI 9416

h 08/14 (y)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



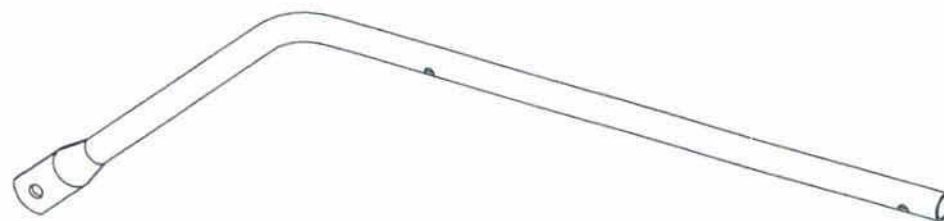
Comment: FINAL INSPECTION/W/O RELEASE

08/10/15 (y)

Job Completion



08/10/15



D2065 ARM

*w/o
40248*

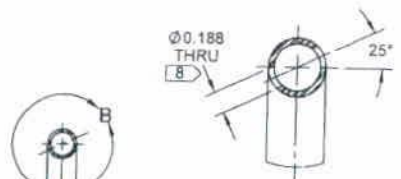
RELEASED
08-07-23-117

C		REDRAWN IN SOLIDWORKS, INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A5-2), ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2), ADD R1.50 DIMENSION (ZN D5-2), Ø0.500 X 0.048 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2), REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.13
B		RE-DESIGN	BW	96.02.06
A		NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION		BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D2065	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		ARM	NTS	
DATE	08.06.13			

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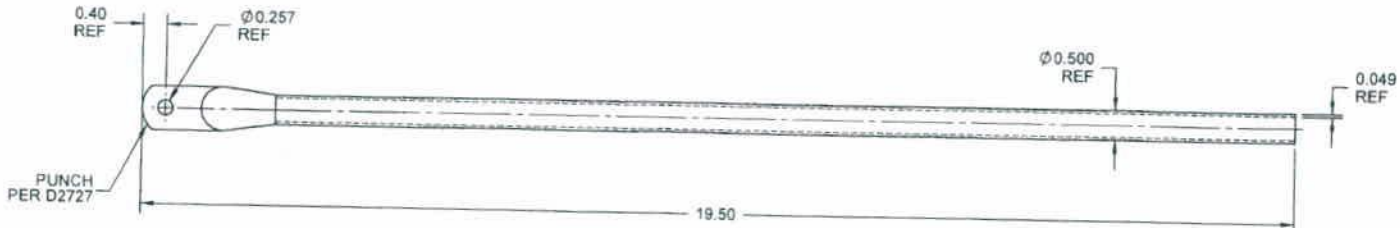
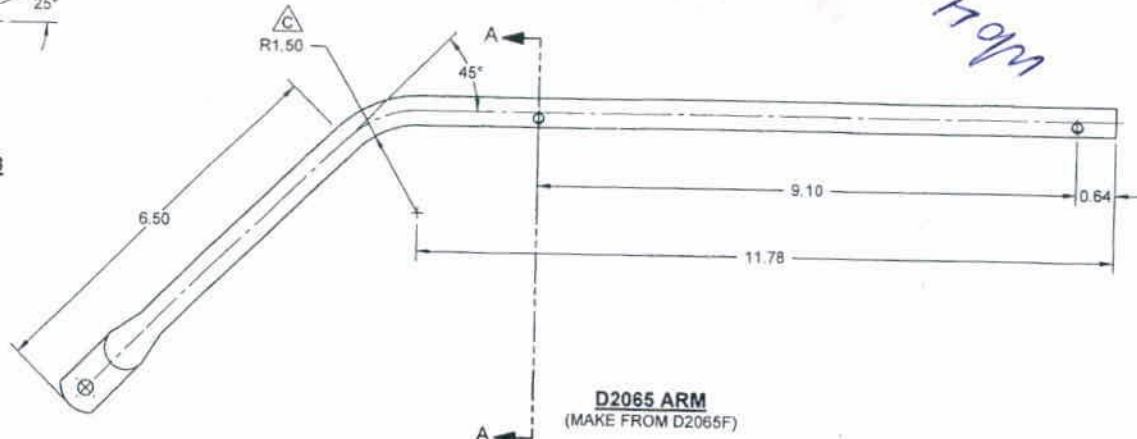
8 7 6 5 4 3 2 1

8440709m



DETAIL B
SCALE 3X
2 PL

SECTION A-A



D2065F ARM CUT LENGTH DETAIL



NOTES

- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W 049)
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL $\phi 0.188$ AFTER BENDING









RELEASED
08.07.2008

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2065	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/08	10	5 Plugs 02057 B40040 820/8		FF 08/10/08			

Part No: D206-558-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: <u>40748-4</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/08	# 10.0	Durkin Disassembly He 22057 Plugs were not saveable Due to the inside Decal the tubing changed		Scrap all Plugs with Arms and Red Pull from stock B# B40040	08/07/08 FF	 08/07/08 FF		 08/07/08
				B# B40040		 08/10/08		 08/10/08

NOTE: Date & initial all entries

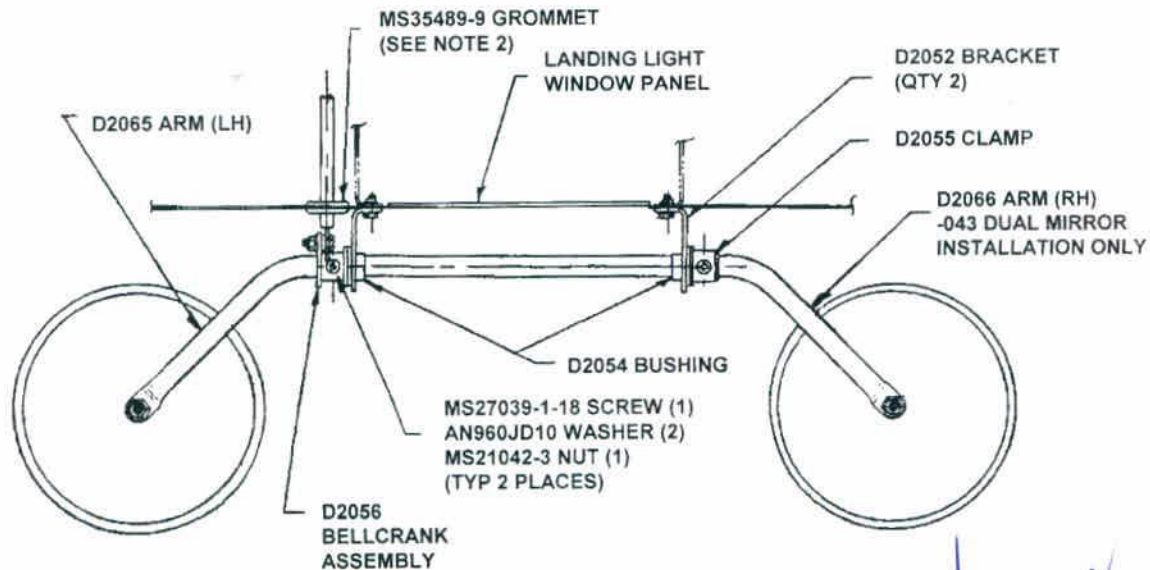


Figure 25.2 – View A: Looking Aft.
(D206-558-043 Mirror Shown)

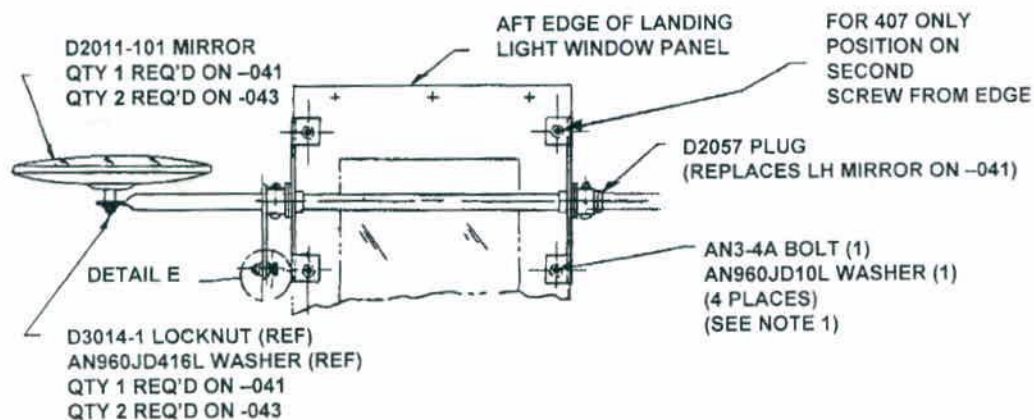


Figure 25.3 – View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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 Job Number : 40748
 Estimate Number : 10804
 P.O. Number :
 This Issue : 24/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run : 00015
 Written By :
 Checked & Approved By :
 Comment :

Part Number : D206558041
 Drawing Number : ECN08-504
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 05/08/2008 Qty: 18 Um: Each

split
(9)
split

REFERENCE ONLY

Additional Product

Job Number:

**REFERENCE ONLY**

Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3X D206-558-041 B 38580 ✓ FFx3 08-07-30

PULL FROM STOCK

3 X D206-558-041 B39281

10 X D206-558-041 B39398

5 X D206-558-041 B39399

✓ FFx10 } 08-07-30
 ✓ FFx5 }

2.0

D206558041

Single Cargo Mirror Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)

Single Cargo Mirror Assembly

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

CUT ARMS TO REMOVE ALL COMPONENTS

D2011-101 MIRROR

D2052 MTG BRKT

D2054 BUSHING

D2055 CLAMP

D2056 BELL CRANK

D2057 PLUG

PUT COMPONENTS ASIDE TO RE-USE WITH NEW ARM

DISCARD HARDWARE

MANUFACTURE NEW ARMS WITH .049 WALL MAT'L

FF 08-07-30

FF 08-07-30